

# Work Order ID 92987

Tuesday, November 13, 2012 7:58:40 AM

\*92987\*

Ship Nov. 13  
06th soon

Page 1

Item ID: DSI 9594-011

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Fwd Ground Handling Spacer

Start Date: 11/13/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 11/22/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan:

MF

Date:

12-11-23

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

DSI 9594

A

100

\*100\*

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile & type labels per PPP DSI 9594-011 CHG001

0.00

0.00

12-11-14

12-11-13

110

\*110\*

Packaging

Packaging

Pick Kit

Memo

0.00

0.00

12-11-13

120

\*120\*

QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

0.00

0.00

12-11-14

**Work Order ID 92987****\*92987\***

Page 2

Tuesday, November 13, 2012 7:58:40 AM

Item ID: DSI 9594-011

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Fwd Ground Handling Spacer

Stop

**\*NS2\***

Start Date: 11/13/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 11/22/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

0.00

**\*130\***

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP DSI 9594-011

Location: 032

sf sk 12/11/13

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

12/11/15 dg

W12-11-14

# Picklist Print

Tuesday, November 13, 2012 7:58:40 AM

Page 1

Work Order ID: 92987

Parent Item: DSI 9594-011

Parent Item Name: Fwd Ground Handling Spacer

Start Date: 11/13/2012

Required Date: 11/22/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.02.27 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2579 Crossbolt Spacer		Manufactured	No			110	Each	135.0000					

8012-11-13

Signature

Sm

## Location

Location	Loc Qty
LG	90
92473	90
LG001	45
62400	22
70761	3
72199	1
72672	7
78371	12

## Loc Code

4x

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D119-646 REV. B,  
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D119-646 REV. 1 OR EARLIER,  
REF. FAA STC SR02024SE

## 1.0 PURPOSE

The purpose of this DSI is to provide instructions for customers to add fwd ground handling holes to their D119-646-XXX skid tubes using the DSI 9594-011 Kit. One kit modifies 2 skid tubes.

## 2.0 PROCEDURE

Modify the skid tubes as follows:

- 2.1 Rotate the D3407-041 Tow Ring to the vertical position as necessary.
- 2.2 Mark holes in the center ridge as shown in Figure 1. Drill through skid tube with  $\varnothing$  0.500" (12.7 mm drill), and countersunk to  $\varnothing$  0.650 x 100°, two places per side.
- 2.3 Deburr holes. Touch up affected area with chemical film material (Alodine 1200 or 1201) per MIL-C-5541.
- 2.4 Bond D2579 spacers into the  $\varnothing$  0.500 holes center in the skid tube using Magnobond 6398. Grind flush prior painting as shown in Figure 1.
- 2.5 Apply one coat of MIL-P-85582 or MIL-P-2337 primer and 2-3 coats of MIL-C-83285 polyurethane coat to match original finish.
- 2.6 Repeat steps 2.1 to 2.5 for opposite skid tube.

## 3.0 PART LIST

Qty -011	PART NUMBER	DESCRIPTION
X	DSI 9594-011	FWD GROUND HANDLING SPACER KIT
<del>4</del>	<del>D2579</del>	<del>CROSS BOLT SPACER</del>

## 4.0 WEIGHT AND BALANCE

This modification has negligible effect on weight and balance.

A	NEW ISSUE	RF	12.02.03
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	<del>RF</del>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9594	SHEET 1 OF 2
APPROVED	<del>RF</del>	TITLE	SCALE
DE APPR.	<del>RF</del>	FWD GROUND HANDLING SPACER KIT	NTS
DATE	12.02.03	COPYRIGHT © 2012 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	